Item ID: D350-607-141

Revision ID:

Item Name: Automatic Lid Opener Installation

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/27/12   **Start Qty:** 1.00   *1*

Required Date: 8/24/12   **Req'd Qty:** 1.00   *1*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Approvals: **Process Plan:** MLJ   **Date:** 12/08/07 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D350-607-1	A								

100 *100* DC Document Control	Memo Photocopy bluefile &type labels per PPP D350-607-141 CHG001	0.00 0.00							APV CL 12-9-7
110 *110* Packaging Packaging	Pick Kit Memo	0.00 0.00							12/09/07 JB
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
NCR No. _____	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped.	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	

Item ID:	D350-607-141		Accept	***N9000401nn***	Setup	Start	***NS1***
Revision ID:						Stop	***NS2***
Item Name:	Automatic Lid Opener Installation						

Start Date:	7/27/12	Start Qty: 1.00	***1***	Cust Item ID:
Required Date:	8/24/12	Req'd Qty: 1.00	***1***	Customer:

Reference:

					Run	Start	***NR1***
Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____		Stop	***NR2***
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____			

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 ***130*** Packaging Packaging		0.00							
	Memo Identify and pack for shipping as per PPP D350-607-141 Location:_____ PPP rev:_____	0.00						_____	
140 ***140*** QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00						_____	

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	
Part No. _____	
NCR No. _____	

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Work Order Update	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	

Picklist Print

August-01-12 3:20:04 PM

Work Order ID:	**88344**		
Parent Item:	**D350-607-141**	**Start Date:** 7/27/12	**Required Date:** 8/24/12
Parent Item Name:	Automatic Lid Opener Installation	**Start Qty:** 1.00	**Required Qty:** 1.00

Comments: IPP RevA: New issue DD verified by:EC   IPP RevB: as per dwg revC DD
10.01.18 verified by:EC   IPP Rev:C as per ecn10-545 DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3953-1 Gas Spring Bracket		Manufactured	No			110	Each	13.0000	2	2			

Location	Loc Qty	Loc Code
ST075	13	
53760	13	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3953-3 Gas Spring Stud, Lid		Manufactured	No			110	Each	55.0000	2	2			

Location	Loc Qty	Loc Code
GA	40	
87592	40	
ST075	15	
85788	15	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3953-5 Gas Spring Stud, Base		Manufactured	No			110	Each	38.0000	2	2			

Location	Loc Qty	Loc Code
ST075	38	
85958	18	
86593	20	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3953-7 Spring Spacer		Manufactured	No			110	Each	73.0000	2	2			

Location	Loc Qty	Loc Code
ST075	23	
85789	23	
ST078	50	
87444	50	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order: _____	**DISPOSITION**		**AGAINST DEPARTMENT/PROCESS**			
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
NCR No. _____	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped.	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	

Work Order ID:	**88344**							
Parent Item:	**D350-607-141**				**Start Date:** 7/27/12		**Required Date:** 8/24/12	
Parent Item Name:	Automatic Lid Opener Installation				**Start Qty:** 1.00		**Required Qty:** 1.00	

D3953-9
Gas Spring Washer   Manufactured   No   110   Each   61.0000   *4*   4   *JB*

Location	Loc Qty	Loc Code
ST075	1	
82941	1	
ST078	60	
87539	60	

D3953-11
Gas Spring Spacer   Manufactured   No   110   Each   21.0000   *87539*   *2*   *JB*

Location	Loc Qty	Loc Code
ST075	1	
79338	1	
ST078	20	
87089	20	

D3953-13
Gas Spring Spacer   Manufactured   No   110   Each   10.0000   *87089*   *2*   *JB*

Location	Loc Qty	Loc Code
ST075	10	
52761	10	

D3969-1
Spring (Basket Lid)   Manufactured   No   110   Each   21.0000   *52761*   *2*   *JB*

Location	Loc Qty	Loc Code
ST272	21	
73523	1	
84424	20	

AN3C11A
BOLT   Purchased   No   110   Each   32.0000   *84424*   4   *JB 12/09/07*

Location	Loc Qty	Loc Code
ST351	32	
119798	32	

119798

NCR: Yes / No   **WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order: _____	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**

Part No. _____

NCR No. _____

DISPOSITION
- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS
- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear
- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped.
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General
- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio

- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions

- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge

- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____
_____

August-01-12 3:20:04 PM

Work Order ID:	88344					
Parent Item:	D350-607-141			Start Date: 7/27/12	Required Date: 8/24/12	
Parent Item Name:	Automatic Lid Opener Installation			Start Qty: 1.00	Required Qty: 1.00	

AN3G16A
Bolt   Purchased   No   110   Each   37.0000   4   4

Location	Loc Qty	Loc Code
ST352	37	
115835	1	
121349	25	
121652	11	

121652

AN310-4
NUT   Purchased   No   110   Each   76.0000   4   4

Location	Loc Qty	Loc Code
ST344	76	
121349	2	
121827	74	

121827

MS21043-3
Nut   Purchased   No   110   Each   799.0000   8   8

Location	Loc Qty	Loc Code
FG	72	
103691	72	
ST301	727	
118077	2	
118614	7	
118686	30	
119758	20	
121255	20	
121708	648	

121708

MS24665-2-12
COTTER PIN   Purchased   No   110   Each   122.0000   4   4

JB 12/09/07

Location	Loc Qty	Loc Code
ST309	122	
118078	122	

118078

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐   Crosstube ☐   Water Jet ☐   Engineering ☐
Machining ☐   Small Fab ☐   Prod. Eng. Coor. ☐   Quality ☐
Thermoforming ☐   Finishing ☐   Rec/Store/Packaging ☐   Other ☐
Large Fab ☐   Composite ☐   Supplier ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped.
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

Work Order ID:	88344				
Parent Item:	**D350-607-141**		**Start Date:** 7/27/12	**Required Date:** 8/24/12
Parent Item Name:	Automatic Lid Opener Installation		**Start Qty:** 1.00	**Required Qty:** 1.00

NAS1149C0332R
Washer

Purchased   No   110   Each   5,208.0000   8   8   *JB*

Location	Loc Qty	Loc Code
297	5208	
122063	5208	

122063

NAS1149C0432R
Washer

Purchased   No   110   Each   5,924.0000   4   4   *JB 12/09/07*

Location	Loc Qty	Loc Code
296	3000	
122441	3000	
ST297	1070	
117291	70	
119124	1000	
ST298	1854	
121255	1854	

121255

DY12-698.031/&032

WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Yes / No

DQA: _____ ·Date: _____

QA Closed: _____ Date: _____

Work Order: _____	**DISPOSITION**		**AGAINST DEPARTMENT/PROCESS**				
Part No. _____	Rework ☐		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	
	Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
NCR No. _____	Work Order Update ☐		Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped.	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	

6.3 D350-607-141/-143/-145 AUTOMATIC LID OPENER INSTL

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-607-141	AUTOMATIC LID OPENER INSTL (FOR USE ON -041 BASKET)
	X		D350-607-143	AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET)
		X	D350-607-145	AUTOMATIC LID OPENER INSTL (FOR USE ON -045 BASKET)
2		1	D3953-1	GAS SPRING BRACKET
2	1	1	D3953-3	GAS SPRING STUD (LID)
2	1	1	D3953-5	GAS SPRING STUD (BASE)
2	1	1	D3953-7	GAS SPRING SPACER
4	2	2	D3953-9	GAS SPRING WASHER
2	1	1	D3953-11	GAS SPRING SPACER
2		1	D3953-13	GAS SPRING SPACER
	1		D3953-15	GAS SPRING BRACKET
	1		D3953-17	GAS SPRING SPACER
2	1	1	D3969-1	GAS SPRING
4	2	2	AN3C11A	BOLT
	2		AN3C15A	BOLT
4		2	AN3C16A	BOLT
4	2	2	AN310-4	CASTELLATED NUT
8	4	4	MS21043-3	NUT
4	2	2	MS24665-212	COTTER PIN
8	4	4	NAS1149C0332R	WASHER (OR AN960C10L)
4	2	2	NAS1149C0432R	WASHER (OR AN960C416L)

Revision: A
Date: 10.03.10